

Work Order ID 92714***92714***

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November-07-12 3:07:04 PM

Item ID: D4149-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug Plate, Aft

Start Date: 11/07/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/20/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MCS Date: 12-11-08 Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4149	C
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100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: EDwg Rev: E

304 .125

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

Work Order ID 92714

92714

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November-07-12 3:07:04 PM

Item ID: D4149-1

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N900040100

Setup Start *NS1*

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				15			
120									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: 148	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/11/21 15

12/11/22 JF
MF
12-11-21

Picklist Print

November-07-12 3:07:03 PM

Page 1
T

Work Order ID: 92714

Parent Item: D4149-1

Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 11/07/12

Required Date: 11/20/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	164.2500	0.1355	1.7115792	2	1812-11-9	
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT020		164.25					
						122521		164.25					

15

122521

DART AEROSPACE LTD		Work Order:	92714
Description: Aft Crosstube Lug Plate		Part Number:	D4149-1
Inspection Dwg: D4149 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

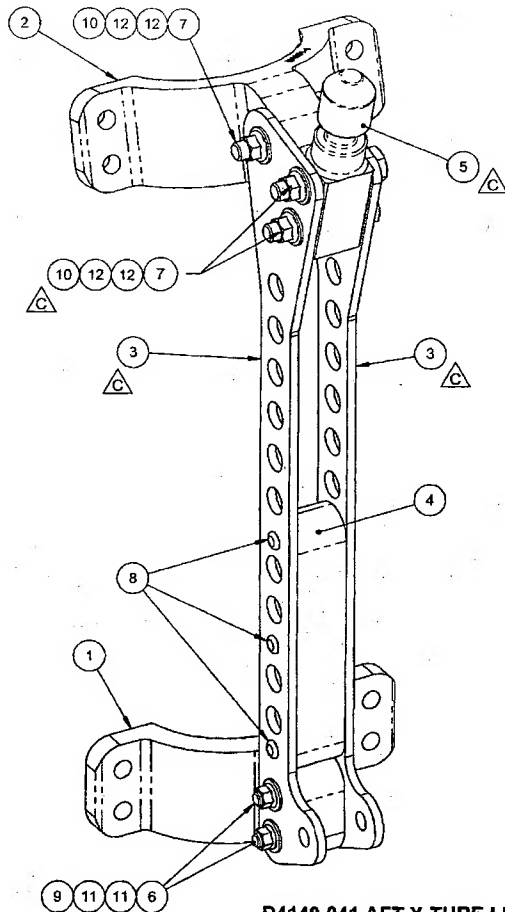
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.133	2		V	Box
Ø0.191	+0.005/-0.001	.193	2		V	
Ø0.257	+0.006/-0.001	.261	2		V	
Ø0.38	+0.006/-0.001	.381	2		V	
0.380	+/-0.010	.381	2		V	
0.469	+/-0.010	.471	2		V	
0.310	+/-0.010	.312	2		V	
0.750	+/-0.010	.758	2		V	
3.25	+/-0.030	3.252	2		V	
0.65	+/-0.030	?			V	
0.63	+/-0.030	.627	2		V	
5.46	+/-0.030	5.460	2		V	
3.80	+/-0.030	3.80	2		V	
2.13	+/-0.030	2.127	2		V	
1.313	+/-0.010	1.310	2		V	
0.625	+/-0.010	.623	2		V	
0.375	+/-0.010	.380	2		V	
1.175	+/-0.010	1.179	2		V	
0.752	+/-0.010	.750	2		V	
1.588	+/-0.010	1.590	2		V	
1.587	+/-0.010	1.589	2		V	
11.15	+/-0.030	11.15	2		Protractor	
0.750	+/-0.010	.744	2		V	
1.55	+/-0.030	1.553	2		V	
1.12	+/-0.030	1.123	2		V	
8.42	+/-0.030	8.42	2		P	
2.70	+/-0.030	2.76	2		V	
0.125	+/-0.010	.118	2		V	
Ø0.252	+0.003/-0.000	.253	2		V	

Measured by:	R
Date:	12-11-9

Audited by:	DA 15 2-89
Date:	12-11-20

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	AA



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

UNCONTROLLED
SUBJECT TO
W. R.
W. R.

NO. 92714 MJS
12-11-08

RELEASED
2011-02-24
JW

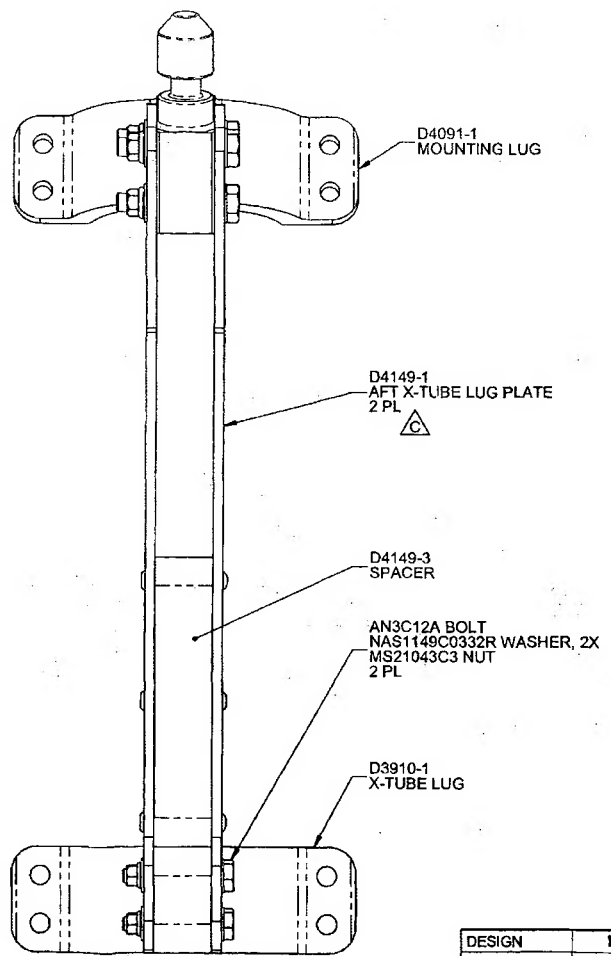
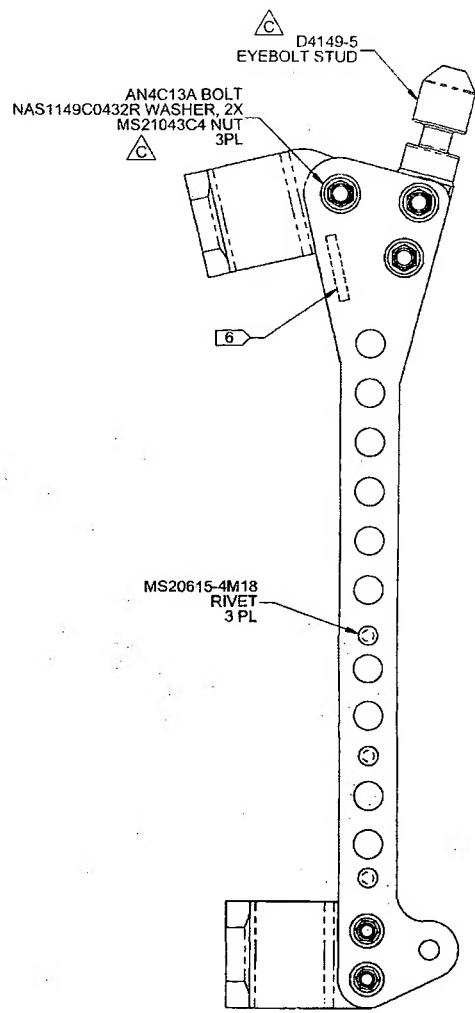
C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(5) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.128 3 PL (ZN D8-3); REASON: SEE TR-0350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4149** REV. C
SHEET 1 OF 5
TITLE **AFT X-TUBE LUG ASSY** SCALE NTS

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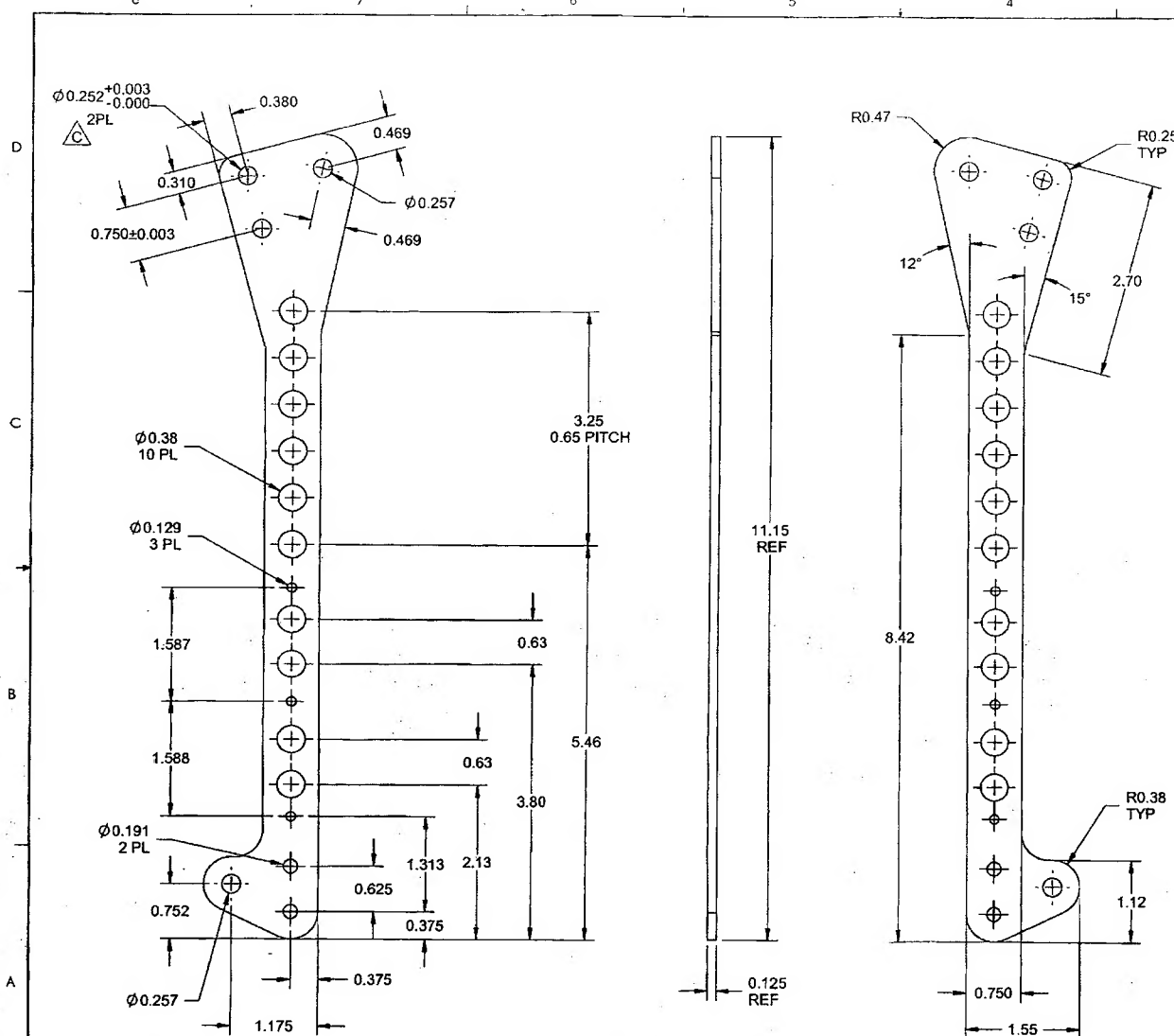


D4149-041 AFT X-TUBE LUG ASSY

RELEASED
2011-02-24
MP

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
CE APPR.		AFT X-TUBE LUG ASSY	NTS
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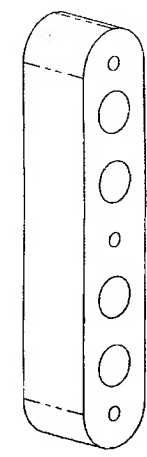
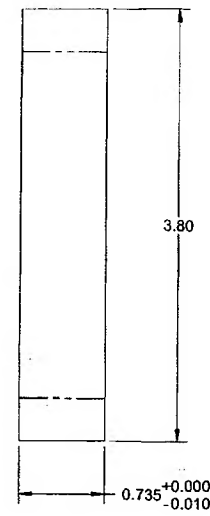
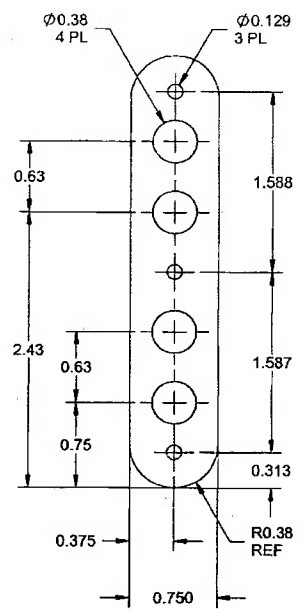
D4149-1 AFT X-TUBE LUG PLATE

RELEASED
2011-02-24

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240
OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4149	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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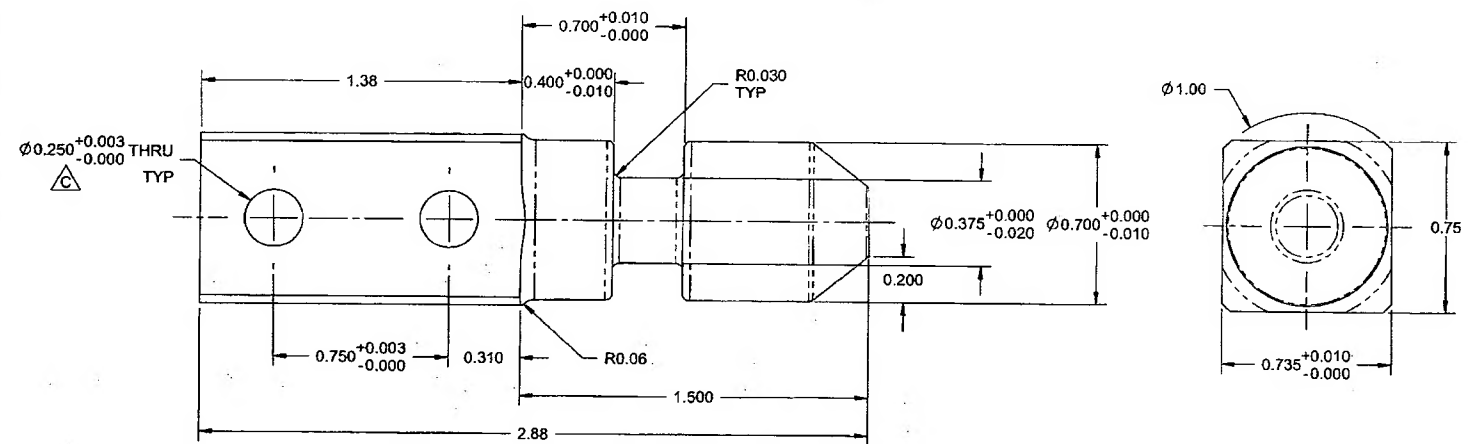
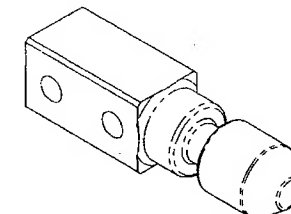
D4149-3 SPACER

RELEASED
2011-02-24

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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92714



D4149-5 EYEBOLT STUD

RELEASED
2011-02-24

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.			SHEET 5 OF 5
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